

Date: Thursday, 12/20/2007 3:24:29 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HELI-ACCESS STEP LH (FOLDING)	
Job Number	36496		Part Number	D412630033	
Estimate Number	12567		Drawing Number	IIN D412-630	
P.O. Number			Project Number	N/A	
This Issue	12/20/2007	S.O. No. :	Drawing Revision	L	
Prsh Rev.	NC		Material		
First Issue	/ /	Type :	Due Date	1/30/2008	Qty: <u>3</u>
Previous Run	35956		Um:	Each	
Written By	<u>201221</u>				
Checked & Approved By					
Comment	Est. Rev A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	Batch			
1.0	DC	DOCUMENT CONTROL	<u>K3 08.01.22</u>			
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003 <p style="text-align: right;"><i>Placed labels on front end of step. No room on the arm.</i></p> <p style="text-align: right;"><i>06.02.27</i></p>						
2.0	D2012107	Clevis	<u>33585</u>			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description <table border="1" style="margin-left: 20px;"> <tr> <td>1</td> <td>D2012-107</td> <td>Clevis</td> </tr> </table>				1	D2012-107	Clevis
1	D2012-107	Clevis				
3.0	D2803041	Bracket Assembly	<u>358262X</u>			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description <table border="1" style="margin-left: 20px;"> <tr> <td>1</td> <td>D2803-041</td> <td>Bracket Assembly LH</td> </tr> </table>				1	D2803-041	Bracket Assembly LH
1	D2803-041	Bracket Assembly LH				
4.0	D2804041	Bracket Assembly	<u>27282 10</u>			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description <table border="1" style="margin-left: 20px;"> <tr> <td>1</td> <td>D2804-041</td> <td>Bracket Assembly LH</td> </tr> </table>				1	D2804-041	Bracket Assembly LH
1	D2804-041	Bracket Assembly LH				
<u>23435 14</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

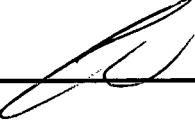
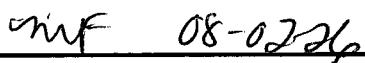
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36496			Part Number: D412630033
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	D2807041	GAS SPRING ASSEMBLY 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Support Prop Batch: <u>35962</u>			
6.0	D2813	Washer 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Washer Pick: Qty Part Number Description Batch 2 D2813 Washer <u>326699 4X</u> 			
7.0	D3562041	STEP ASSEMBLY, LH 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch 1 D3562-041 Step Weldment LH <u>B36497</u> 			
8.0	D33951	Bushing 	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 4 D3395-1 Bushing <u>B26770</u> 			
9.0	AN3C21A	BOLT 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) BOLT Pick: Qty Part Number Description Batch 2 AN3C21A Bolt <u>M19633 4X</u> 			
10.0	AN8C16	Bolt 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bolt Pick: <u>M100690 5X</u>  <u>M102736 1X</u> 			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 36496

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
	Qty Part Number Description	Batch
	2 AN8C16 Bolt	<u> </u>
11.0	AN310C8 Nut	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Nut	
	Pick:	
	Qty Part Number Description	Batch
	2 AN310C8 Nut	<u>M10 0433</u>
12.0	MS24665302 Cotter Pin	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
	Cotter Pin	
	Pick:	
	Qty Part Number Description	Batch
	2 MS24665-302 Cotter Pin (or AN380C3-4)	<u>M10 6763</u>
13.0	NAS1515H3 Washer	
	Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)	
	Washer	
	Pick:	
	Qty Part Number Description	Batch
	6 NAS1515H3 Washer	<u>M10 6431</u>
14.0	NAS1515H5L WASHER	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	WASHER	
	Pick:	
	Qty Part Number Description	Batch
	4 NAS1515H5L Washer	<u>M10 1920 1X M105792 11X</u>
15.0	NAS1515H8 Washer	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)	
	Washer	
	Pick:	
	Qty Part Number Description	Batch
	4 NAS1515H8 Washer	<u>M106540</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 36496

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	m107214

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	m101390 3X m16984 3X

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: m104929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON

BATCH: m17045

mf 08-02-26 ③

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D28061	Bushing	027245 3X 026565 3X

029383 1X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 36496

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2806-1 Bushing

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	36534

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	2703

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	34025

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M106079

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M101189

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 36496			Part Number: D412630033
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
27.0	AN4C15A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
Bolt Pick: Packing Kit			
Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	<i>M103910</i>
28.0	AN44C7A	Eyebolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Eyebolt Pick: Packing Kit			
Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	<i>M1962020 M101711 14</i>
29.0	AN5C15A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
Bolt Pick: Packing Kit			
Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	<i>M1816724 M10422840</i>
30.0	NAS1515H4	Washer	
Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)			
Washer Pick: Packing Kit			
Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	<i>M105516</i>
31.0	NAS1515H5	Washer	
Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)			
Washer Pick: Packing Kit			
Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	<i>M106041</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36496

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0 MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M107101

33.0 MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M107101

34.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Kits separated.

35.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: 8

8b1227

SC

3x

AB

36.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/20/07

(3)

Job Completion



2008/12/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36496

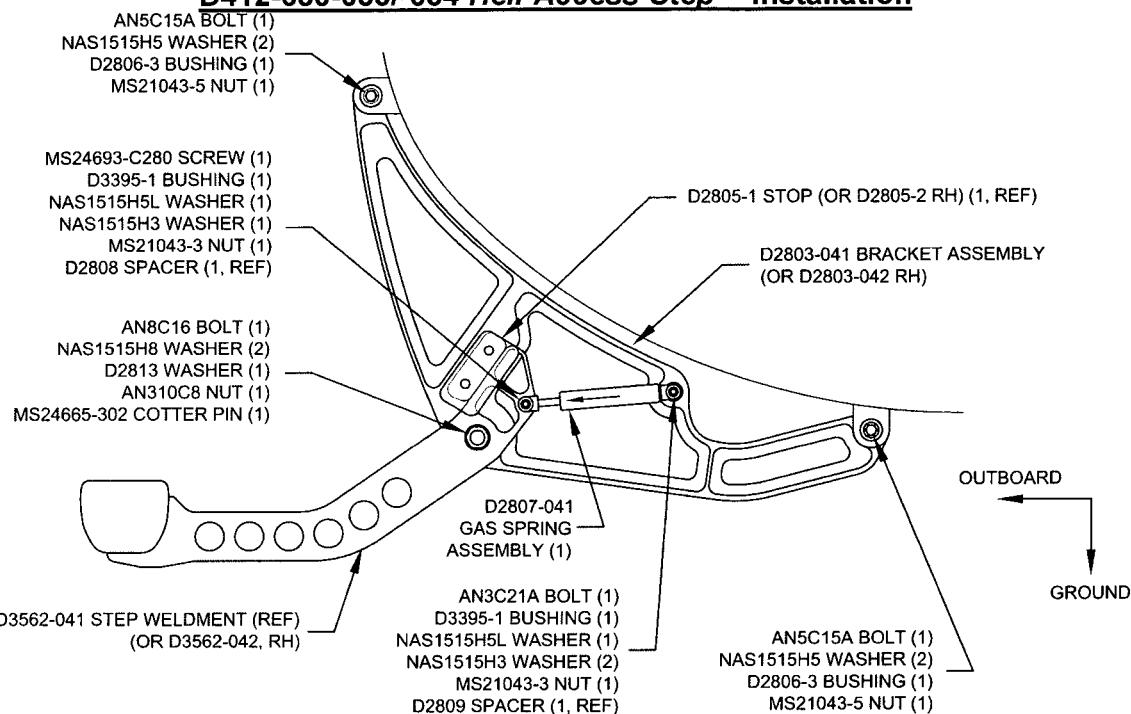
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

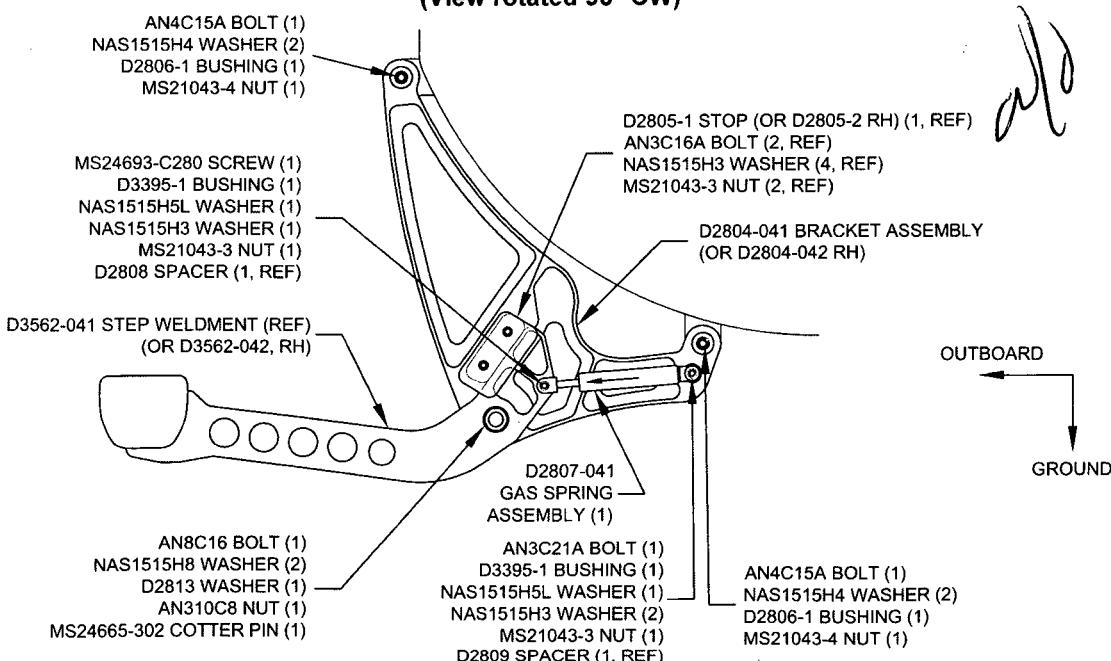


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)